

Work Order ID 153371

Monday, November 21, 2016 7:42:40 AM

153371

Page 1

Item ID: K591-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Short Step Installation

Start Date: 12/19/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/9/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

VS **DAS**
21
9-89

Date:

12/11/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9525	A								
104	Pick Kit	DAS 6 9-89 0.00						DAS 21 9-89	<i>1701-20</i> 8
104									
Packaging	Memo	0.00							
Packaging									
105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.03							
Quality Control									
110	Identify as per dwg & Stock Location:	0.00							
110									
Packaging	Memo	0.01							
Packaging	***CHG005***								

4X PPP153370
4X Fg 125

8X **DAS**
28
9-89

JAN 20 2017

DAS
26
9-89

DAS
27
9-89

JAN 20 2017

Work Order ID 153371

Monday, November 21, 2016 7:42:40 AM

153371

Page 2

Item ID: K591-113

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Step Installation

Start Date: 12/19/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/9/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		JAN 23 2017
120									
QC	Memo	0.10							
Quality Control							DAS 21 9-89		JAN 23 2017

Monday, November 21, 2016 7:42:45 AM

153371

K591-113

Required Date: 1/9/2017

Required Qty: 6.00

IPP Rev:D
IPP Rev:E as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 *D2171* Clamp		Manufactured	No			104	Each	24.0000	2	12	6	JAN 20 2017	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST542				24					
					151392			8					
					152356			16					
D2274 *D2274* Radius Block		Manufactured	No			104	Each	466.0000	4	24	6	JAN 20 2017	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				12					
					86855			12					
				ST006				454					
					150353			1					
					151763			453					
D2182B *D2182R* Rubber Cushion - Black (\$Per Foot)		Manufactured	No			104	f	238.2100	0.5833	3.4998	6	JAN 20 2017	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST411				238.21					
					135093			238.21					

Picklist Print

Monday, November 21, 2016 7:42:45 AM

Page 2

Work Order ID: 153371

153371

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 12/19/2016

Required Date: 1/9/2017

Start Qty: 6.00

Required Qty: 6.00

D2362-3 Manufactured No

104 Each

2.0000

D2362-3
Step Support Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST537

2

148544

2

104 Each

13.0000

D3595-200-300 Manufactured No

D3595-200-300
Rubber Cushion 2.00" wide x 3.00" Long

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

1

84209

1

ST416

12

150885

12

104 Each

73.0000

AN3-37A Purchased No

AN3-37A
Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

over005

30

m135945

30

ST347

33

m133694

1

m135135

3

m135530

29

1

**

8x B152 177

DAS
6
9-89

DAS
26
9-89

JAN 20 2017

DAS
27
9-89

1

**

DAS
6
9-89

DAS
26
9-89

JAN 20 2017

DAS
27
9-89

154314 x 1

JAN 20 2017

2

**

DAS
6
9-89

DAS
26
9-89

DAS
27
9-89

100x

4x

Picklist Print

Monday, November 21, 2016 7:42:45 AM

Page 3

Work Order ID: 153371

153371

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 12/19/2016

Required Date: 1/9/2017

Start Qty: 6.00

Required Qty: 6.00

AN4-21A Purchased No

104 Each

100.0000

4

24

AN4-21A

Bolt

**

DAS
6
9-89

JAN 20 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

94

m133640

44

m133694

50

ST342

6

m132716

6

24x
8x.

DAS
26
9-89

AN4-22A Purchased No

104 Each

69.0000

1

88

AN4-22A

Bolt

**

DAS
6
9-89

JAN 20 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

50

116419

50

ST342

19

123348

19

8x
24x

DAS
6
9-89

DAS
26
9-89

NAS1149D0363J Purchased No

104 Each

1,018.000

4

24

NAS1149D0363J

Washer

**

DAS
6
9-89

JAN 20 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

364

m134055

364

ST263

654

m135864

654

m136318

DAS
26
9-89

DAS
28
9-89

Picklist Print

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Page 4

Work Order ID: 153371

153371

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 12/19/2016

Required Date: 1/9/2017

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0463J

Purchased

No

104

Each

2,944.000

6

35 48

NAS1149D0463.J

Washer

**

DAS

6

9-89

JAN 20 2017

DAS

26

9-89

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST260a

1600

M136044

1600

ST263

1264

M135671

3

M135767

261

M135948

1000

m136406

MS21042L3

Purchased

No

104

Each

1,857.000

2

12/19/16k

MS21042L3

Nut

**

DAS

6

9-89

JAN 20 2017

DAS

26

9-89

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

200

m134360

108

m135135

92

OVER007

600

M136044

600

ST303

1050

m135767

450

m135945

600

m136192

Picklist Print

Page 5

Monday, November 21, 2016 7:42:45 AM

Work Order ID: 153371

153371

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 12/19/2016

Required Date: 1/9/2017

Start Qty: 6.00

Required Qty: 6.00

MS21042L4

Purchased

No

104

Each

1,820.000

5

MS21042L4

Nut

**

30 40
m136295 SP
DAS 27
9-89
JAN 9 2017
DAS 6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

200

m135058

200

OVER007

500

m135979

500

ST303

1086

m135774

86

m135864

1000

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

V/c
62
16/11/21

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153371

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				DSI-9525-011	STEP CUSHION KIT (FOR D350-591-111A)
	X			DSI-9525-013	STEP CUSHION KIT (FOR D350-591-113/-119)
		X		DSI-9525-015	STEP CUSHION KIT (FOR D350-591-115)
			X	DSI-9525-017	STEP CUSHION KIT (FOR D350-591-117A)
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:

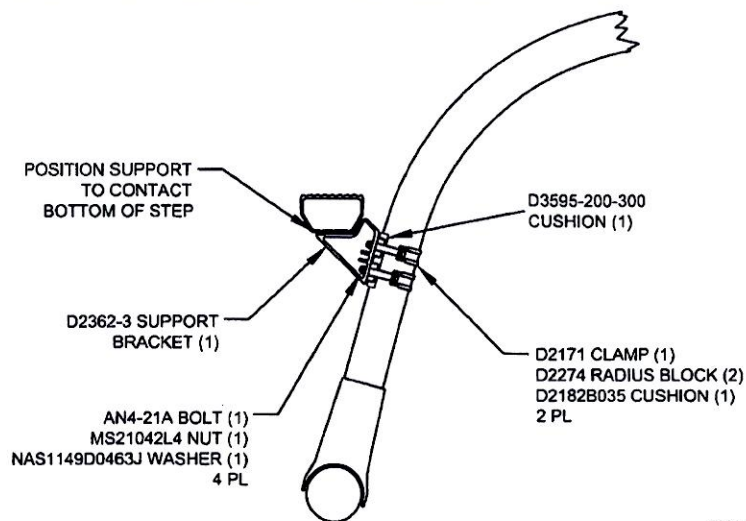
THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

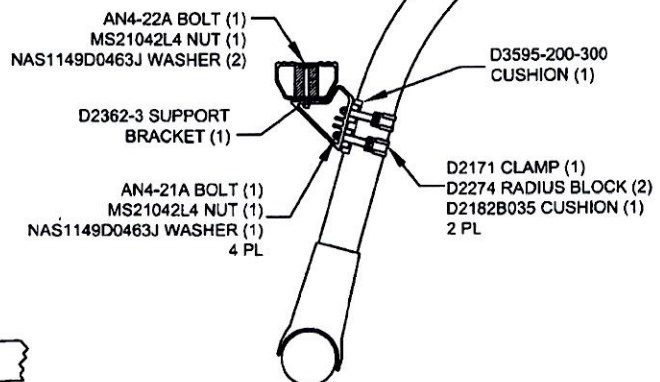
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BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

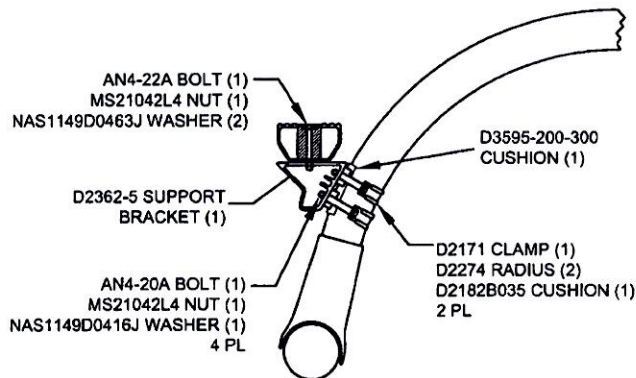
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 2 OF 4
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SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

FIGURE 32-9: Crosstube Attachment
REF ICA-D350-591

FIGURE 9: Crosstube Attachment
REF D350-591

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	10.06.08
CERT. NO.:	SH92-6
ISSUE NO.:	11

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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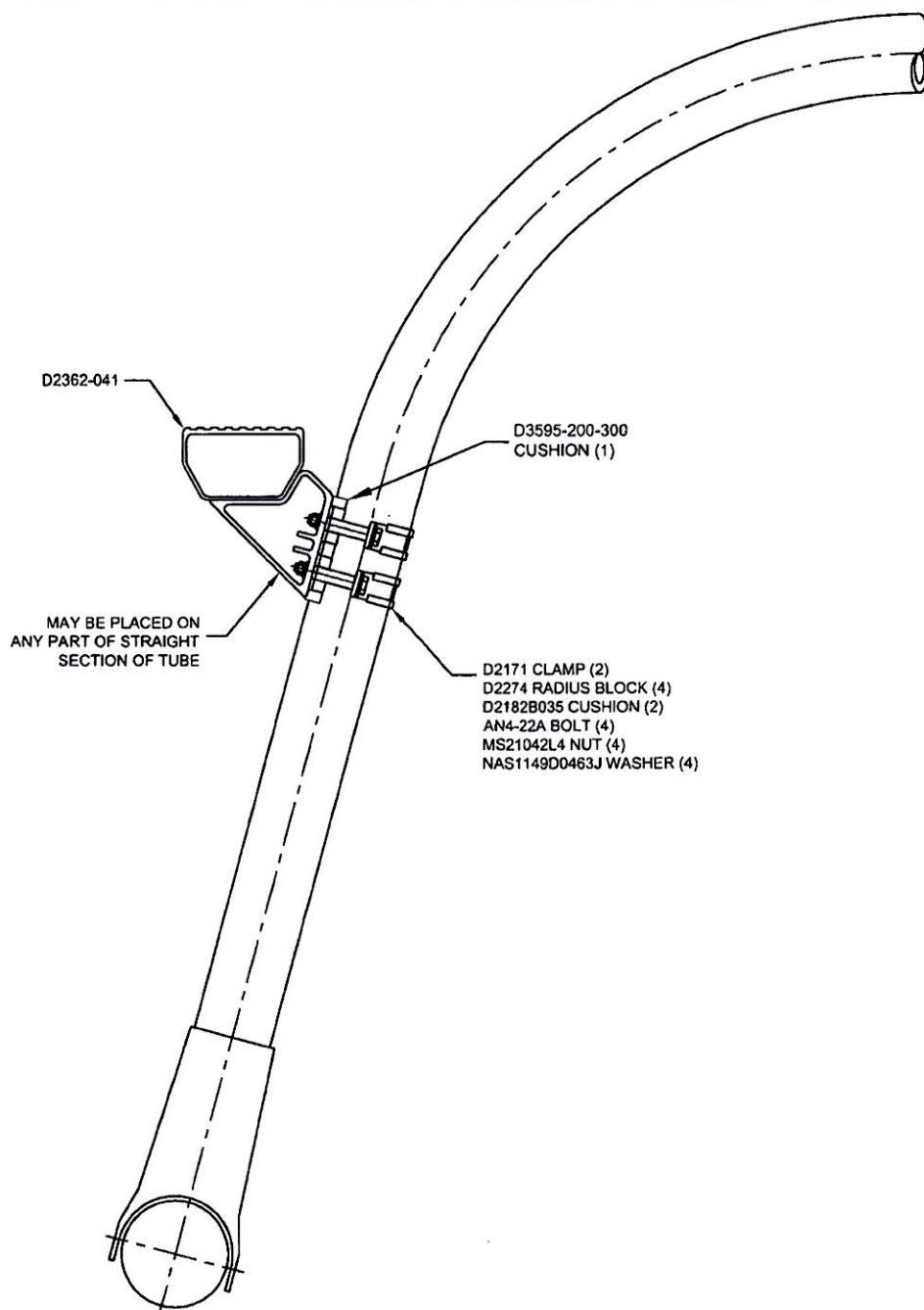


FIGURE 32-10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 4 OF 4
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

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A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
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DE APPR.		STEP CUSHION CHANGE	NTS
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